



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D350-748-243TRN
Job Sheet 173672



Part No: D350-748-243TRN

Job Qty: 1 ea

Part Name: Crosstube Installation, High Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A IPP Rev: PRELIM New Issue LL 12.05.08

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/17/18	0.00	0.00	Start Up Crosstubes-1		PMP
100	Mori Seiki	1 pcs		4/17/18	2.01	3.57	Mori Seiki TL-40		PMP
110	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		PMP
120	Mori Seiki	1 pcs		4/17/18	0.00	3.57	Mori Seiki TL-40		PMP
130	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		PMP
140	QC	1 pcs		4/17/18	0.00	0.00	QC8		PMP
150	Crosstubes	1 pcs		4/18/18	0.00	0.81	Crosstubes-2		GP
190	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging3-1		GP
200	QC21-SA	1 Ea		4/18/18	0.00	0.00	QC21		GP

Part Op 100 - 1-Cut tube on chop saw, leave extra mat'l for facing and install plugs 350-241 on both ends. 3- Turn program 02000 Descriptions: section on both side as per folio FB468. 4- Turn program 03000 section on both side as per folio FB468.

120 - 1- Turn program 04000 section on both side as per folio FB468. 2- Turn program 05000 section on both side as per folio FB468. 3- Blend transition lines only with belt sander 60 grit 4-Scribe part # as per Dwg D350-748-243

130 - PERFORME ULTRASONIC MEASUREMENT

150 - 1-Grind machining marks

190 - Identify and stock in kanban rack

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6021-125	Crosstube Material - 17-4Ph SS	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6021-125	1	71	0

8127 272

Part Specifications

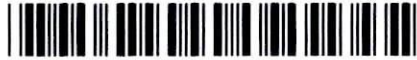
Specifications could not be found.

Plex 3/6/18 12:35 PM Dart.Gagnon.Michelle



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Container No: S055291



Part: D350-748-243TRN

Job No: 173672

Serial No/Batch: S055291

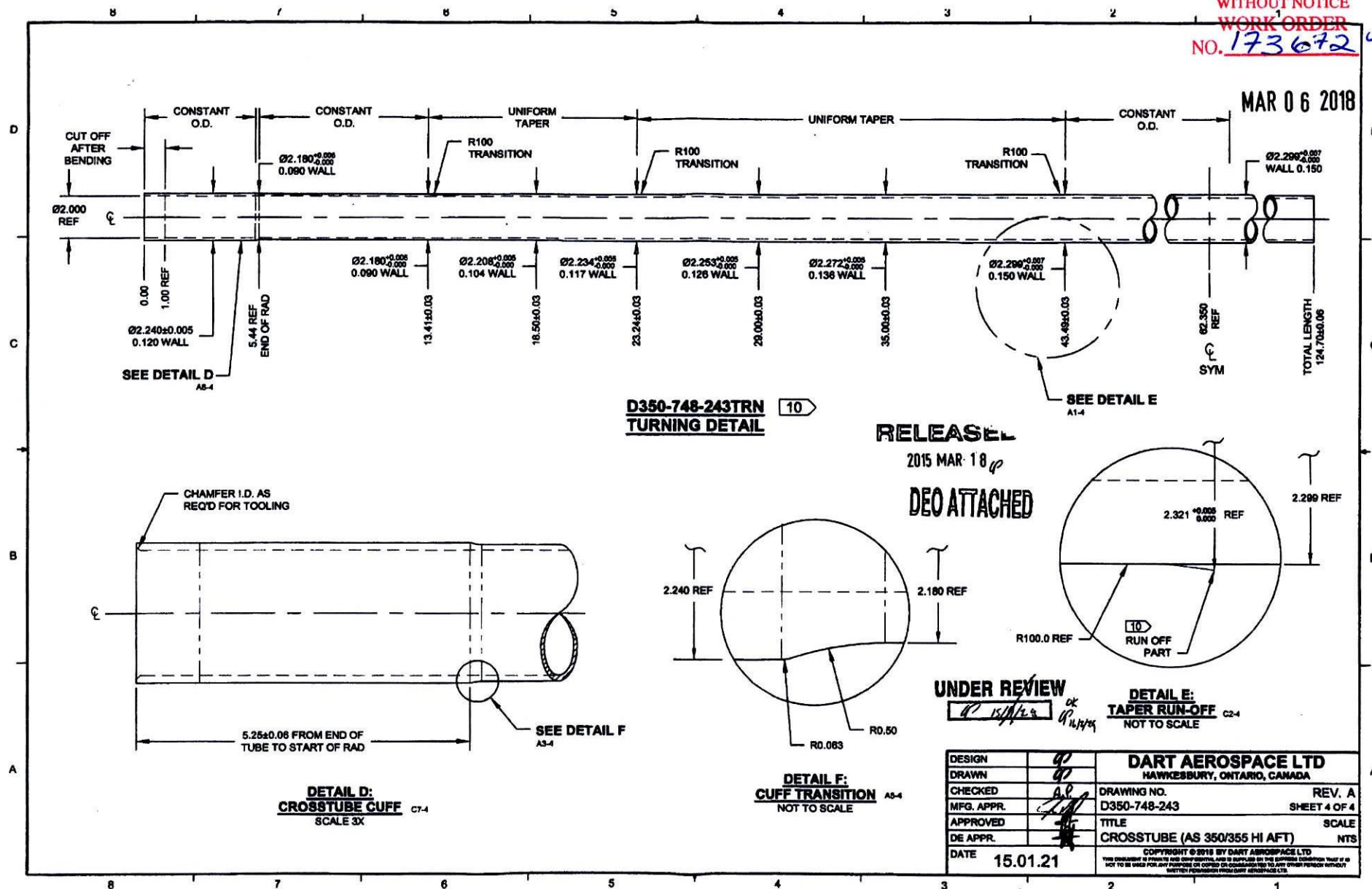
Revision:

Inspector:

Date: 03/27/18

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173672

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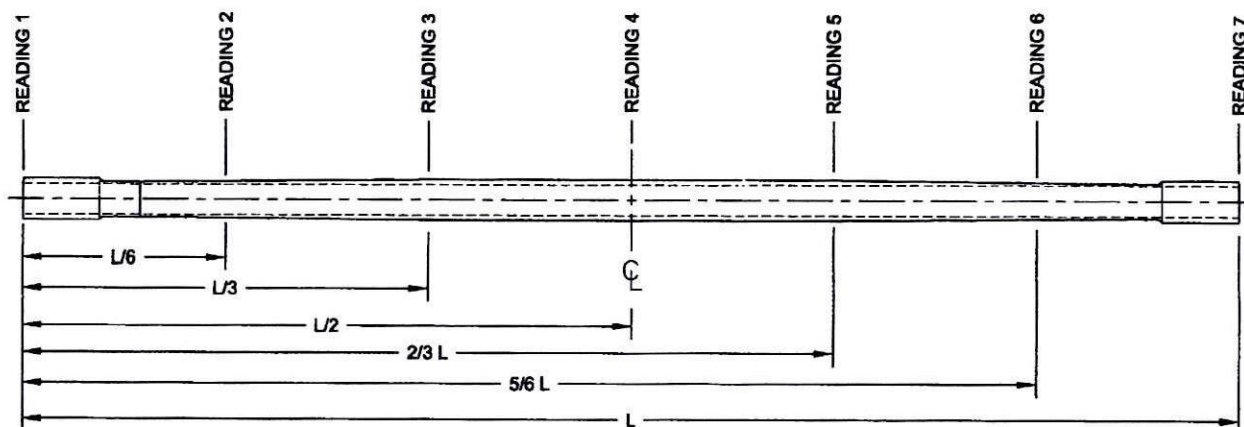
DART AEROSPACE LTD	Work Order:	173672
Description: Crosstube Assembly (AS350/355 High Aft SS)	Part Number:	D350-748-243
Inspection Dwg: D350-748-243 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+/-0.005	2.243	✓		VERNO8	
	2.180	+0.005/-0.000	2.184	✓		BLM 2"-3"	
	2.180	+0.005/-0.000	2.184	✓			
	2.208	+0.005/-0.000	2.212	✓			
	2.234	+0.005/-0.000	2.238	✓			
	2.253	+0.005/-0.000	2.257	✓			
	2.272	+0.005/-0.000	2.277	✓			
	2.299	+0.005/-0.000	2.306	✓		BLM 2"-3"	
	0.063	+/-0.010	.063	✓		RF	
	5.25	+/-0.060	5.260	✓		VERNO8	
	R0.063	+/-0.010	.063	✓		RF	
	R0.50	+/-0.030	.50	✓		RF	
SIDE B	2.240	+/-0.005	2.242	✓		VERNO8	
	2.180	+0.005/-0.000	2.185	✓		BLM 2"-3"	
	2.180	+0.005/-0.000	2.185	✓			
	2.208	+0.005/-0.000	2.213	✓			
	2.234	+0.005/-0.000	2.239	✓			
	2.253	+0.005/-0.000	2.258	✓			
	2.272	+0.005/-0.000					
	2.299	+0.005/-0.000	2.306	✓		BLM 2"-3"	
	0.063	+/-0.010	.063	✓		RF	
	5.25	+/-0.060	5.258	✓		VERNO8	
	R0.063	+/-0.010	.063	✓		RF	
	R0.50	+/-0.030	.500	✓		RF	
	124.70	+/-0.060	124.7	✓		TAPE	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	123	125	123	125	.002	0.030"
READING 2 L= 20.78	120	107	108	121	.014	
READING 3 L= 41.57	157	151	154	160	.009	
READING 4 L= 62.35	156	160	160	155	.005	
READING 5 L= 83.13	154	159	161	154	.007	
READING 6 L= 103.92	113	121	121	111	.010	
READING 7 L= 124.7	128	121	121	126	.007	

Calibration Result

Actual Block Thickness: 100-200

Sitiescan 250 Measured Thickness: 100-200

Measured by:	PMP
Date:	2018-03-27

Audited by:	
Date:	

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue (P/O D350-748-203)	KJ	